

Date: Friday, 3/24/2006 1:37:05 PM  
 User: Kim Johnston

## Process Sheet

|  |                                      |
|--|--------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WHEEL ASSEMBLY        |
| Job Number : 26325                             |                                      |
| Estimate Number : 12102                        |                                      |
| P.O. Number : N/A                              | Part Number : D33975                 |
| This Issue : 3/24/2006 S.O. No. : N/A          | Drawing Number : D3397 REV.A         |
| Prsht Rev. : NC                                | Project Number : N/A                 |
| First Issue : 3/23/2006 Type : MACHINED PARTS  | Drawing Revision : A                 |
| Previous Run :                                 | Material : N/A                       |
| Written By : <u>SEE COMMENT BELOW</u>          | Due Date : 3/30/2006 Qty: 5 Um: Each |
| Checked & Approved By : <u>06.03.24</u>        |                                      |
| Comment : est rev. A New issue EC              |                                      |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |                 |                       |
|-----|-----------------|-----------------------|
| 1.0 | M1020TR1375W125 | COLD DRAWN ROUND TUBE |
|-----|-----------------|-----------------------|



Comment: Qty.: 0.1313 f(s)/Unit Total : 0.6563 f(s)

AISI 1020-1025 ROUND TUBE

Dia. 1.375" x 0.125" wall

batch: M17015

06/04/10

|     |             |                    |
|-----|-------------|--------------------|
| 2.0 | LATHE CONV. | CONVENTIONAL LATHE |
|-----|-------------|--------------------|



Comment: CONVENTIONAL LATHE

Turn as per Dwg D3397

06/04/10

5

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/04/10

5

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

06.04.10

5

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51433

06/04/10

5

|     |    |                  |
|-----|----|------------------|
| 6.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/10

5

06.04.10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 26/04/11

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

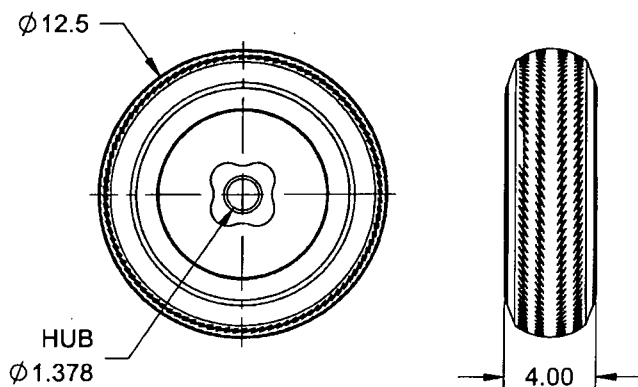
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**DART**

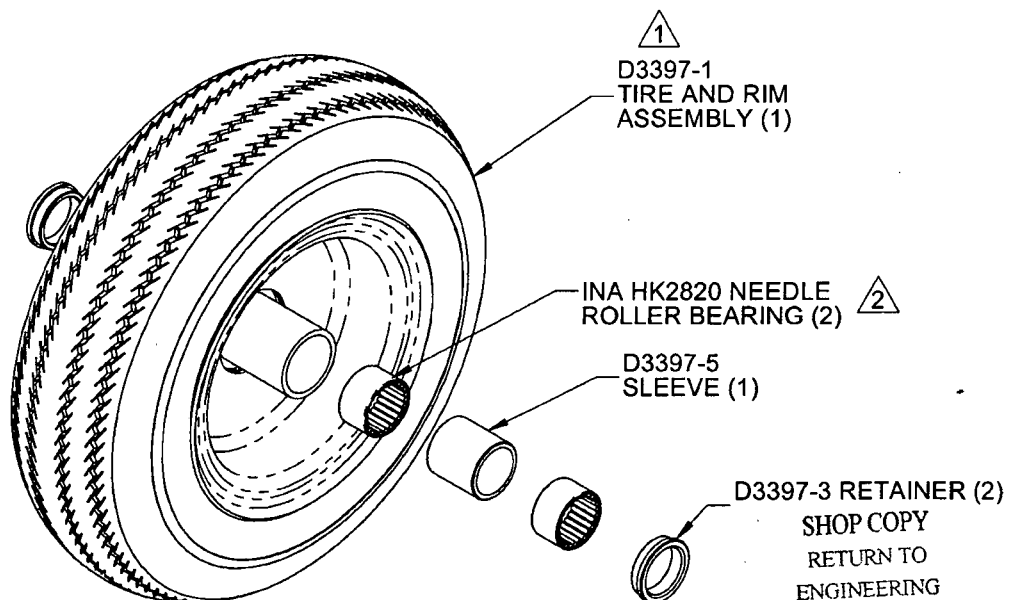
|                               |                                |  |                        |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN<br>RF                  | DRAWN BY<br>RF                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br><b>D3397</b>                              | REV. A<br>SHEET 1 OF 3 |
| DATE<br><b>05.02.10</b>       | TITLE<br><b>WHEEL ASSEMBLY</b> |  | SCALE<br>1:8           |
| A                             | 05.02.10                       | NEW ISSUE  |                        |



| WHEEL SPECIFICATIONS                                       |              |                        |
|--|--------------|------------------------|
| SIZE   | MAXIMUM LOAD | MAXIMUM INFLATION LOAD |
| TIRE: $\phi 12.4 \times 4.1$<br>RIM: $\phi 6.0 \times 4.0$ | 445 LBS      | 50 PSI*                |

**1 D3397-1 TIRE AND RIM ASS'Y**

**RELEASED**  
*[Signature]*



**D3397-041 WHEEL ASS'Y**

**NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 4997T28. SCRAP ORIGINAL BEARING
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) INFLATE TIRE TO MAX. 50 psi
- 7) APPLY RUST INHIBITOR NOT PROTECTED BY PAINT. RUST INHIBITOR P/N: LPSC30316

D3397-3 RETAINER (2)  
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**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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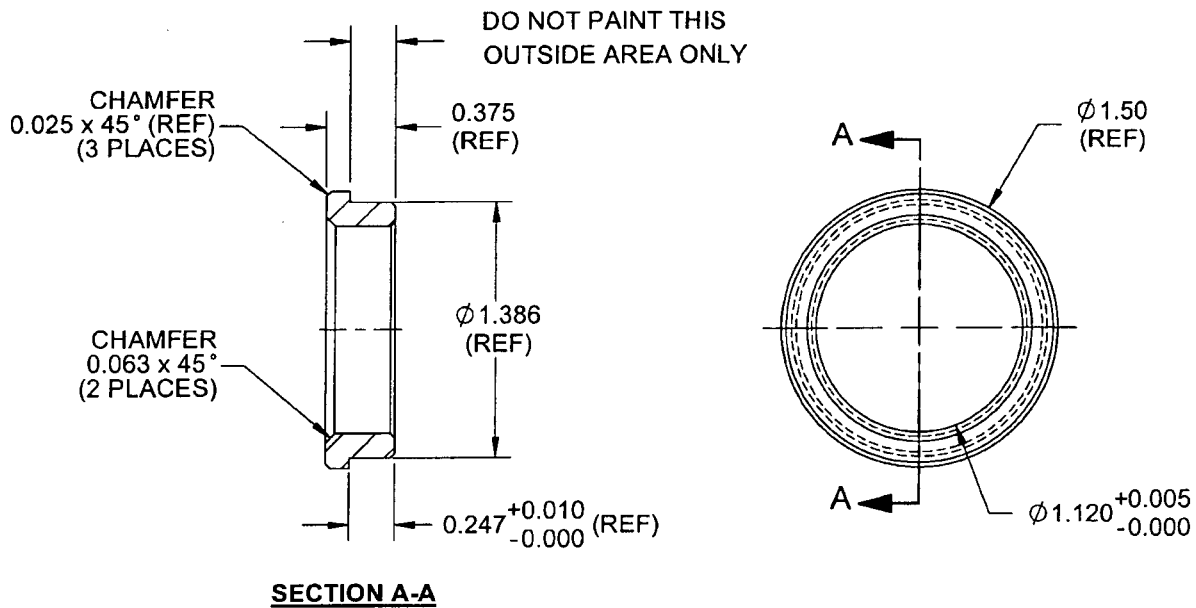
**NOTE:** Date & initial all entries

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|                               |                                |   |                        |
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| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D3397                              | REV. A<br>SHEET 2 OF 3 |
| DATE<br>05.02.10              |                                | TITLE<br>WHEEL ASSEMBLY                           | SCALE<br>1:1           |

**RELEASED**  
*[Signature]* 06/23/09

## SPECIFICATION CONTROL DRAWING



### D3397-3 RETAINER

#### NOTES:

- 1) MATERIAL: REMOVE FROM McMASTER-CARR P/N 4997T28 AND MODIFY AS SHOWN
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.025

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| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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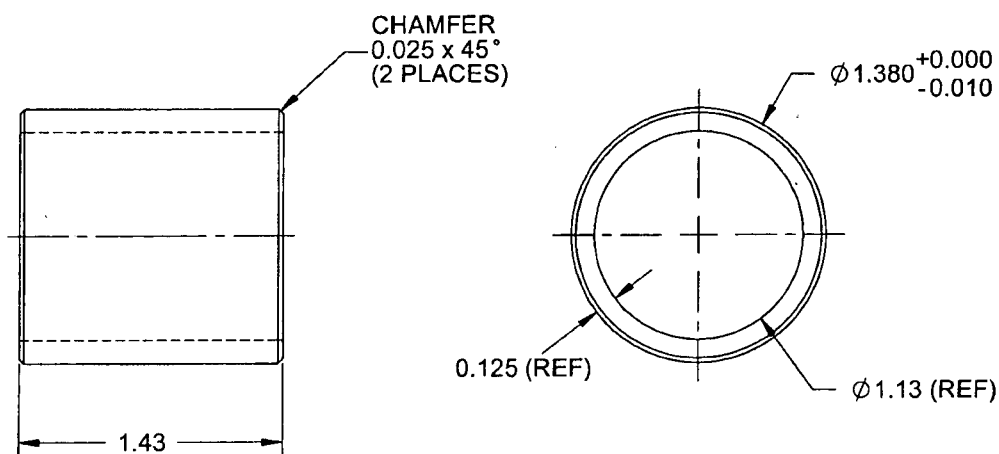
NOTE: Date & initial all entries

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|                  |                         |   |                        |
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| CHECKED<br>3     | APPROVED<br>[Signature] | DRAWING NO.<br>D3397                              | REV. A<br>SHEET 3 OF 3 |
| DATE<br>05.02.10 |                         | TITLE<br>WHEEL ASSEMBLY                           | SCALE<br>1:1           |

**RELEASED**  
R 06/03/03

[Signature]

**D3397-5 SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00  
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS  
(REF. DART SPEC. M1020TR1.375W.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.025

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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

